



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4406-041
Job Sheet 171176



Part No: D4406-041

Job Qty: 6 ea

Part Name: Fwd Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 2/9/18

Type: SOLD

Description:

Note: DWG REV D IPP rev A 11.06.06 new issue EC verified by:DD IPP rev B 12.02.06 as per dwg revPB1 DD
verf:EC IPP REV:C 15.11.16 AS PER PD1 DD VERF:JLM IPP REV:D 16.02.05 AS PER DWG REV.D DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Large Fab-2		OK 18/02/14
150	Large Fab	6 pcs		2/8/18	0.00	18.18	Large Fab 8		OK 18/02/14
160	QC	6 pcs		2/8/18	0.00	0.00	QC9		PD 18-02-16
165	QC	6 pcs		2/8/18	0.00	0.00	QC5		PD 18-02-16
170	Small Fab	6 pcs		2/9/18	0.00	0.50	Small Fab-6		OK 18-02-18
180	QC	6 pcs		2/9/18	0.00	0.00	QC5		OK 18-02-18
190	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-2		OK 18-02-18
200	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		OK 18-02-18

Part Op 150 - 1- Weld D4407-041 to wearplate as per dwg D4406 304 S.S. Welding Rod BATCH #: 2-

Descriptions: Transfer drill holes in bar

160 - QC9- Inspect visual per QSI004- Fusion Welds

165 - QC5- Inspect part completeness to step on W/O

170 - Apply coating as per dwg D4406

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location: LOCATION : FP002

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4406-1	Plate	6 Ea (1 ea)	90-Start up Operation	
D4407-041	Bar Weldment	12 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4406-1	6	2	0
	D4407-041	12	0	0

Part Specifications

Specifications could not be found.

Plex 1/30/18 8:01 AM Dart.Gagnon.Michelle

Master Unit 000671



Job No 171176

DART
AEROSPACE
S040999



Fwd Wearplate Assembly

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D4406-041

Original Serial #: S040999

Revision:

Operation: Start up Operation 02/09/18

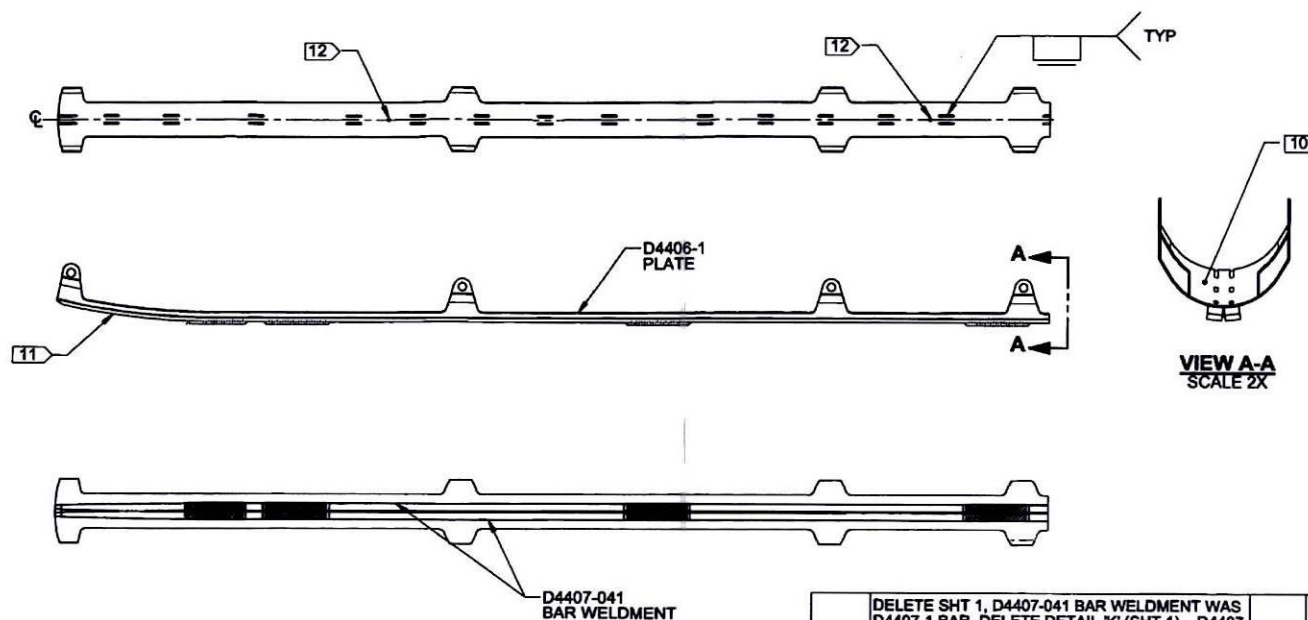
Change No:

Job No: 171176

ITEM	QTY	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171176

14 JUN 2016



D4406-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING.
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-1 TO D4407-041

D	DELETE SHT 1, D4407-041 BAR WELDMENT WAS D4407-1 BAR, DELETE DETAIL 'K' (SHT 1), D4407-043 BAR WELDMENT WAS D4407-3 BAR, DELETE DETAIL 'L' (SHT 2), REMOVE NOTE 9 (SHT 1&2), NOTE 10; TEXTURED COATING WAS ROCKGUARD (SH 1&2), NOTE 12; D4407-041 WAS D4407-1 (SHT 1), D4407-043 WAS D4407-3 (SHT 2), REMOVE NOTE 13 (SHT 1&2)	DB	15.10.14
C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED, SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031)	AJS	13.03.11
B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2&3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4406 REV. D SHEET 1 OF 5 SCALE WEARPLATE ASSY NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	DATE 15.10.14	

RELEASED
2016-02-08
EEN 16-51B

APPROVED